

Work Order ID 128086

Tuesday, January 06, 2015 9:26:18 AM

128086

Page 1

Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop

NS2

Start Date: 1/6/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 1501-06 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Draw Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	C								

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

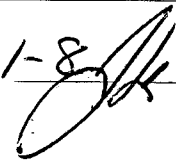
record fwd angle: 89.4°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS
06
9-89

DAS
06
39

FEB 13 2015

15-1-8 

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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop ***NS2***Start Date: 1/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail J to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

DGL 15-1-7

DGL 15-1-8

DGL 15-1-8

15-1-8

BE 15-01-13

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[illegible]

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Stop ***NS2***Start Date: 1/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes									
Skidtubes	Memo	0.00							
	1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float holes using uni-bit to .500" (4 per Side)								
	4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5- Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: <u>131720</u> exp. date: <u>15-10-21</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M30812</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10- Grind welds flush as per Dwg D2750								
	11- Spot face ground handling holes section (total of 4 places per side) as per								

15-1-15 JH

DOL 194 15-1-15.

78150-20

7815-01-21

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Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop *NS2*

Start Date: 1/6/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750								

dwg D2750

12- Deburr holes, ensure tube is free of all scratches before sending to paint.

BE/5-01-21

170

QC10- Inspect visual per QSI004- ground welds	0.00
---	------

170

QC

Memo

0.00

Quality Control

DAS
38
9-89

IAN 22 2015

180

QC5- Inspect part completeness to step on W/O	0.00
---	------

180

OC

Memo

0.00

Quality Control

VERIFY C'BOARD IS GOOD

DAS
38
9-89

JAN 22 2015

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Start Date: 1/6/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1			DAS 41 9-89
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								15-1-30
200		0.00							DAS 41 9-89
200						1			
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>130992</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>131233</u>								15-2-4
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								1RH d 15/02/05 DAS 15 9-89

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Setup Start

NS1

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Stop

NS2

Start Date: 1/6/2015

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/6/2015

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID
230

Operation
Description

Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: MA 131120

EXP DATE: 12108

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: MA 129305 RTU 598 1344 MA125792 exp 15/05

5-Coat all exposed fasteners with "LPS Procyon"

batch: MA 1122900

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

DAS

38

9-89

FEB 10 2015

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Item ID: D350-636-012**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop *NS2*****Start Date:** 1/6/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21 - Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLJ 15-02-23

MF

15-2-20

Picklist Print

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Work Order ID: 128086

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC IPP REV: K
 AS PER REV F JLM 13-08-22 VERIFIED BY: DD
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC
 IPP Rev: N 08-09-23 rev F as per dwg DD verified by: ec IPP Rev: O
 10.06.22 revise seq 110 DD verf: EC IPP Rev: P 10.10.01 as
 per IIN rev H DD verf: EC IPP REV: Q 13.08.27 PER ECN13-
 594 DD VERF: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT-RH		Manufactured	No			110	Each	12.0000	1	1			

D2600-3-BFNT-RH

Extrusion Bent RH

Location	Loc Qty	Loc Code
LG002	12	
125888	12	

DGL 15-1-7

D2744

Manufactured No

110

Each

38.0000

1

1

D2744

Cap

8F15-01-13

Location	Loc Qty	Loc Code
LG001	38	
125894	38	

D2739

Manufactured No

160

Each

13.0000

1

1

D2739

350 I Beam

DGC 15-1-15

Location	Loc Qty	Loc Code
LG003	13	
125868	13	

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D2743

Manufactured No

160

Each

Start Qty: 1.00
155.0000 8 8

Required Qty: 1.00

D2743

Crossbolt Spacer

**

8E15-01-20

Location

Loc Qty

Loc Code

LG001

155

125893

8

127636

147

D3490-3

Manufactured No

160

Each

107.0000 4

4

D3490-3

Cross Bolt Spacer

**

8E15-01-20

Location

Loc Qty

Loc Code

LG001

107

125903

107

D3490-1

Manufactured No

160

Each

117.0000 4

4

D3490-1

Cross Bolt Spacer

**

8E15-01-20

Location

Loc Qty

Loc Code

LG001

117

125902

117

D3631-1

Manufactured No

230

Each

186.0000 8

8

D3631-1

Washer

**

all 2102105

Location

Loc Qty

Loc Code

FP001

186

125912

186

B128320

48

Picklist Print

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Work Order ID: 128086

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3791-1

Manufactured No

230 Each

38.0000 Start Qty: 1.00 1 1

Required Qty: 1.00

D3791-1

Wearpad

**

all 15102105

Location

Loc Qty

Loc Code

FP002

38

125913

38

X1

D3793-3

Manufactured No

230 Each

40.0000 1 1

D3793-3

Wearplate Aft

**

all 15102105

Location

Loc Qty

Loc Code

FP002

40

125915

40

X1

MS21043-6

Purchased No

230 Each

214.0000 4 4

MS21043-6

NUT

**

all 15102105

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

194

m130325

6

m130726

188

X4

D3794-1

Manufactured No

230 Each

36.0000 1 1

D3794-1

Gasket Fwd

**

all 15102105

Location

Loc Qty

Loc Code

FP001

36

124438

1

125916

35

X1

Picklist Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1611-010

Purchased

No

230

Each

Start Qty: 1.00
188.0000 8 8

Required Qty: 1.00

NAS1611-010

O-RING

**

all 15/02/05

Location

Loc Qty

Loc Code

FP001

188

41131329

x8

m130797

188

D2741

Manufactured

No

250

Each

11.0000

1

1

D2741
Replacement Blade

DAS
46
9-89

**

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

1

124047

1

NAS1515H3L

Purchased

No

230

Each

695.0000

4

4

***NAS1515H3L ***

Washer

**

all 15/02/05

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

99

m127831

99

ST266

556

m127831

56

m130726

500

~~B125892~~

x4

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D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1611-013

Purchased

No

230

Each

958.0000

Start Qty: 1.00

8

8

Required Qty: 1.00

NAS1611-013

O-RING

**

ll 15/02/09

Location

Loc Qty

Loc Code

FP001

958

m130758

958

x 8

AN3C6A

Purchased

No

230

Each

616.0000

4

4

AN3C6A

Bolt

**

ll 15/02/05

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

FP001

126

m128769

126

x 4

ST338a

441

m128769

441

NAS1149C0832R

Purchased

No

230

Each

191.0000

1

1

NAS1149C0832R

Washer

**

ll 15/02/05

Location

Loc Qty

Loc Code

FP001

47

m114915

47

x 1

ST271

144

m125807

144

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D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3536-25

Manufactured No

230 Each

38.0000 Start Qty: 1.00 1 1

Required Qty: 1.00

D3536-25

Gasket Center

**

lll 15/02/05

Location	Loc Qty	Loc Code
FG	6	
87053	2	
95328	4	
FP001	32	
125909	32	

xl

D3794-3

Manufactured No

230 Each

75.0000 1 1

D3794-3

Gasket Aft

**

lll 15/02/05

Location	Loc Qty	Loc Code
FP001	75	
124948	1	
125917	34	
127383	39	
92658	1	

xl

AN3C5A

Purchased No

230 Each

1,165.000 34 34

AN3C5A

Bolt

**

lll 15/02/05

Location	Loc Qty	Loc Code
FG	5	
122800	5	
FP001	17	
M130851	17	
ST338a	1143	
M130770	1000	
M130851	143	

x34

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Start Date: 1/6/2015

Required Date: 1/6/2015

D3537-1

Manufactured No

230

Each

67.0000

Start Qty: 1.00

3

Required Qty: 1.00

3

D3537-1

Wearpad

**

lll 15/02/05

Location

Loc Qty

Loc Code

FG

18

79833

8

13128225

88562

10

x3

FP001

49

125418

3

126306

46

D3535-25

Manufactured No

230

Each

10.0000

1

1

D3535-25

Wearplate Center

**

lll 15/02/05

Location

Loc Qty

Loc Code

FG

2

95077

2

13127851

FP002

8

125908

8

x1

D3492-3

Manufactured No

230

Each

210.0000

8

8

D3492-3

Plug

**

lll 15/02/05

Location

Loc Qty

Loc Code

FP001

210

125905

210

13128476

x8

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Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1149C0332R

Purchased

No

230

Each

4,519.000

38

38

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

WASHER

**

all 15/02/05

Location

Loc Qty

Loc Code

FP001

2657

m130325

2657

GA

126

125654

126

ST271

1736

m130325

736

m130466

1000

x38

D3488-042

Manufactured

No

230

Each

2.0000

1

1

D3488-042

Blade Fitting RH

**

all 15/02/07

Location

Loc Qty

Loc Code

FP001

2

B125899

x1

125901

2

ALS4-1032-225

AELS8-1032-225

Purchased

No

230

Each

1,622.000

38

38

ALS4-1032-225

Rivnut

**

all 15/02/07

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

698

M131067

698

x38

st549

804

M131067

804

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Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3492-1

Manufactured No

230

Each

189.0000

Start Qty: 1.00

Required Qty: 1.00

8 8

D3492-1

Plug

**

ll 15102162

Location

Loc Qty

Loc Code

FP001

189

B129057

x8

125904

189

D3793-1

Manufactured No

230

Each

44.0000

1

1

D3793-1

Wearplate Fwd

**

ll 15102105

Location

Loc Qty

Loc Code

FP002

44

125914

43

x1

126905

1

AN8C35A

Purchased No

230

Each

27.0000

1

1

AN8C35A

Bolt

**

ll 15102105

Location

Loc Qty

Loc Code

FG

5

121275

5

11131364

x1

FP001

22

m130114

1

m130784

21

MS21083C8

Purchased No

230

Each

116.0000

1

1

MS21083C8

Nut

**

ll 15102105

Location

Loc Qty

Loc Code

ST300

116

m131049

116

x1

Picklist Print

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Parent Item: D350-636-012

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Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D2745

Manufactured No

230

Each

92.0000

Start Qty: 1.00

8

8

Required Qty: 1.00

D2745

Bushing

**

lll 1510202

Location

Loc Qty

Loc Code

FP001

92

B127585

✓ 8

125895

92

AN6C44A

Purchased

No

230

Each

110.0000

4

4

AN6C44A

Bolt

**

lll 15102105

Location

Loc Qty

Loc Code

FG

2

103964

2

FP001

4

K1131362

✓ 4

m130863

4

ST286A

17

m130863

17

ST332

11

m130863

11

ST333

76

m131151

76

D3532-1

Manufactured

No

250

Each

32.0000

2

2

D3532-1

Spacer

**

DAS
27
9-89

DAS
46
9-89

FEB 12 2015

DAS
96
9-89

Location

Loc Qty

Loc Code

ST048

32

125907

32

Picklist Print

Tuesday, January 06, 2015 9:26:21 AM

Page 11

Work Order ID: 128086

128086

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

MS21083C8

Purchased

No

250

Each

Start Qty: 1.00
116.0000 2 2

Required Qty: 1.00

MS21083C8

Nut

DAS
46
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST300

116

116

758.0000

FEB 12 2015

NAS1149D0863J

Purchased

No

250

Each

Start Qty: 1.00
116.0000 2 2

Required Qty: 1.00

NAS1149D0863J

Washer

DAS
46
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

700

125268

600

125635

100

st268

1

125268

1

109.0000

FEB 12 2015

D3493-1

Manufactured

No

250

Each

Start Qty: 1.00
116.0000 2 2

Required Qty: 1.00

D3493-1

Washer

DAS
46
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

99

125906

99

FEB 12 2015

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

Tuesday, January 06, 2015 9:26:21 AM

Shop Packet Print

Page 11

Picklist Print

Tuesday, January 06, 2015 9:26:21 AM

Page 12

Work Order ID: 128086

128086

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

AN8C21A

Purchased

No

250

Each

Start Qty: 1.00
20.0000 (2) 2

Required Qty: 1.00

AN8C21A

Bolt

DAS
46
9-89

**

DAS
27
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	2	
123966	2	
ST332	18	
m131100	18	

m131247

2

FEB 12 2015

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-6/-7); UPDATED FINISH OPTIONS, INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	JS	KENT, WA	
CHECKED	JS	DRAWING NO.	REV. G
MFG. APPR.	JS	D2750	SHEET 1 OF 11
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	350 SKIDTUBE ASSEMBLY	
DATE	13.07.11	NTS	

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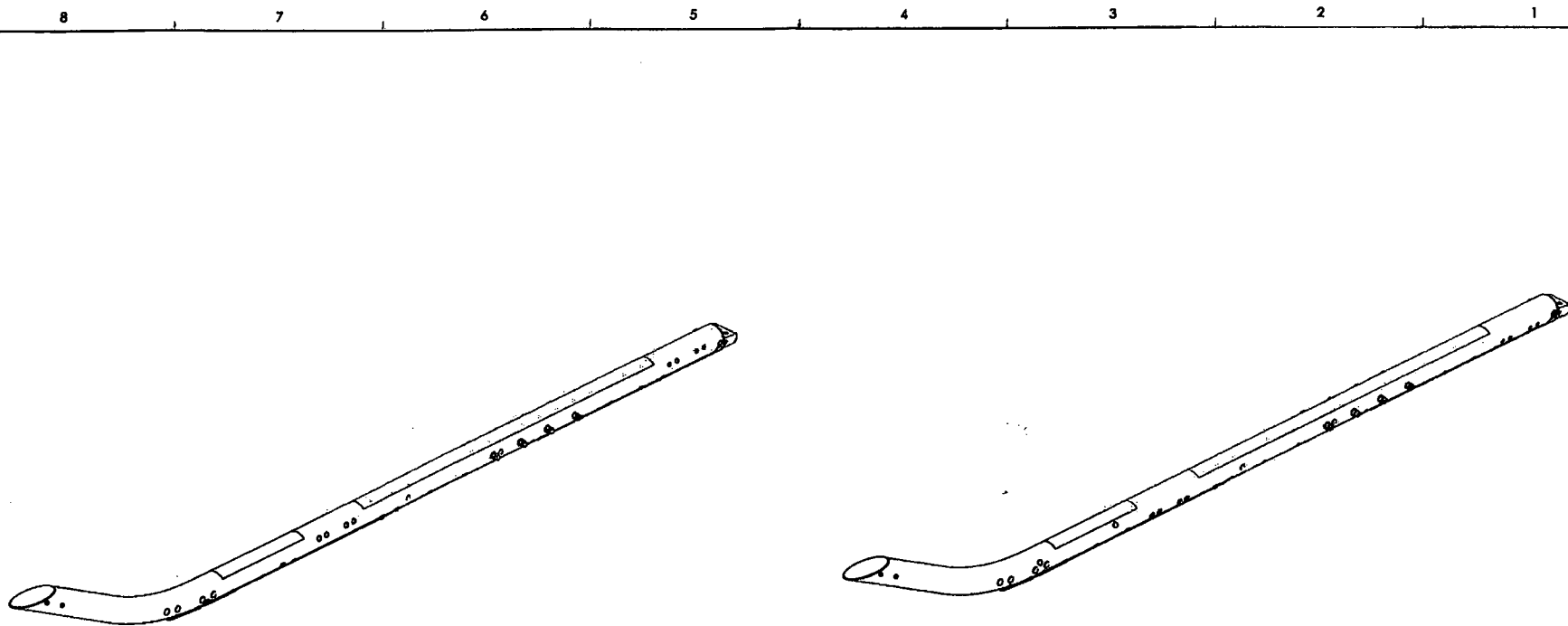
NO 128086 HCS

1501-06

RELEASED

2013-08-13

WD



D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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D

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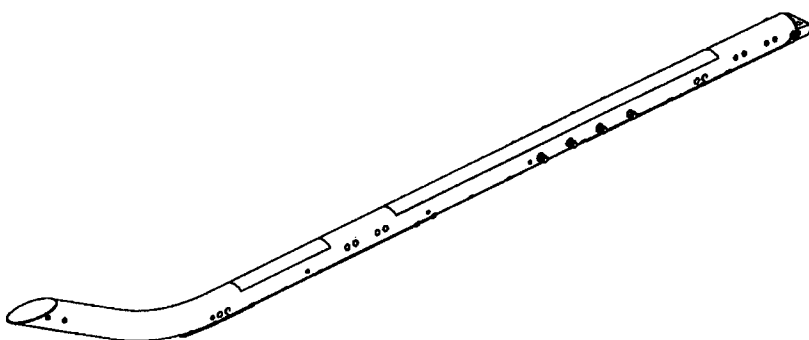
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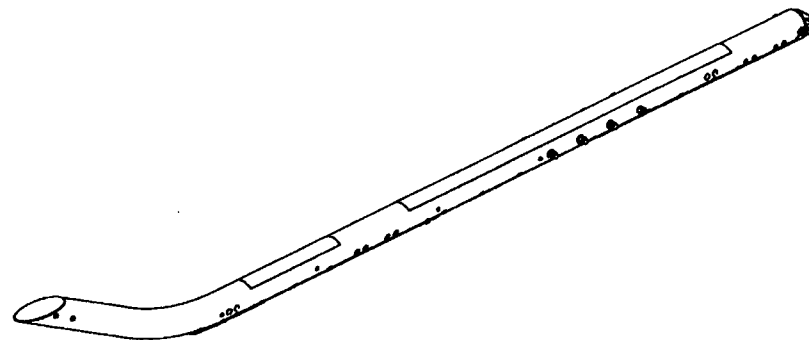
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A

A



D2750-043 350 SKIDTUBE ASSEMBLY, LH

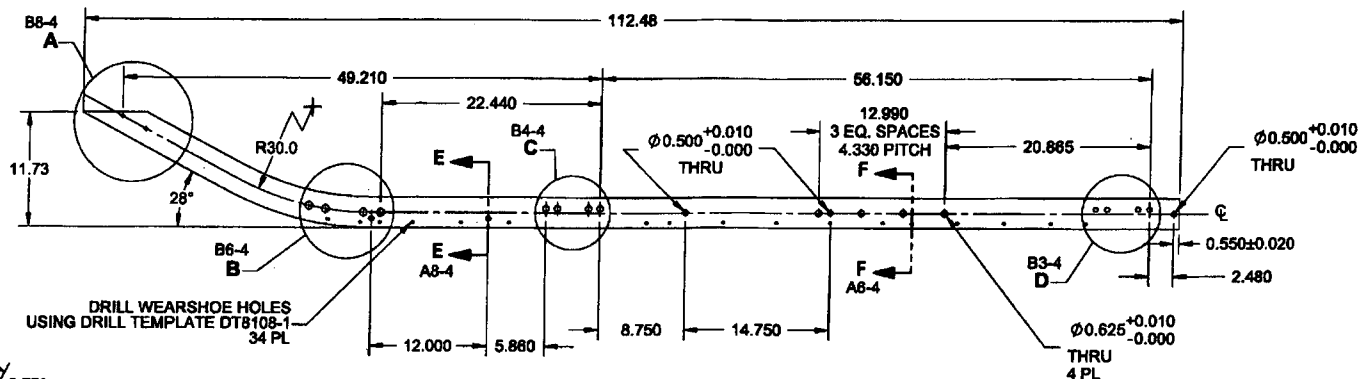


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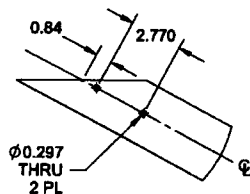
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2013-08-13

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MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 11	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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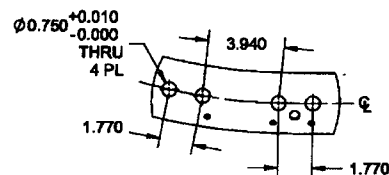
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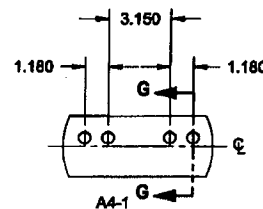
D2750-1 LH SKIDTUBE



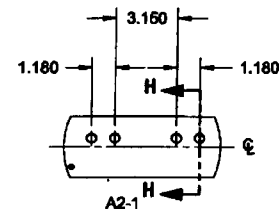
DETAIL A
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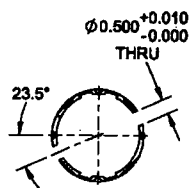
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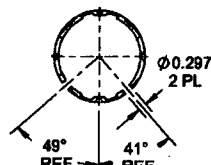
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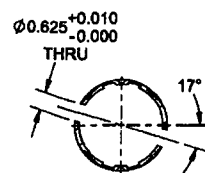
DETAIL D
SCALE 2X



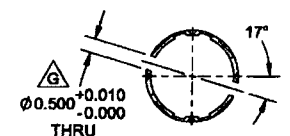
SECTION E-E
SCALE 3X, 2 PL



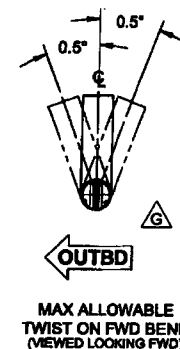
SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



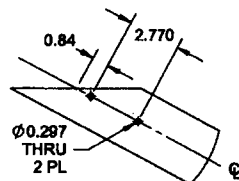
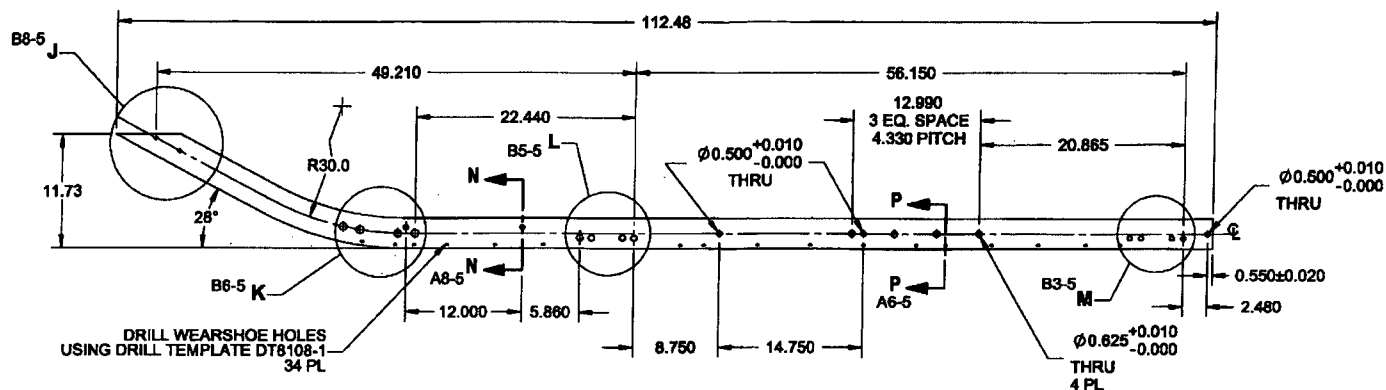
SECTION H-H
SCALE 3X, 4 PL



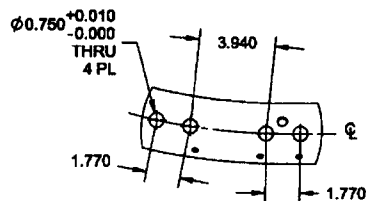
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

RELEASED
2013-08-13

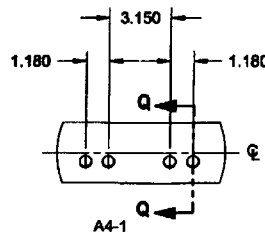
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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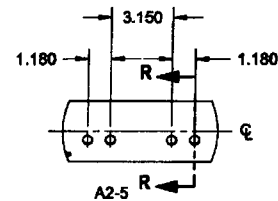
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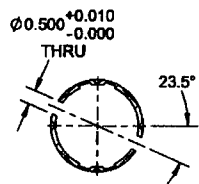
C7-5
SCALE 2X



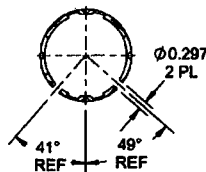
D6-5
SCALE 2X



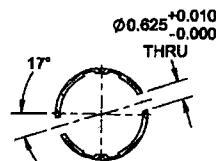
C3-5
SCALE 2X



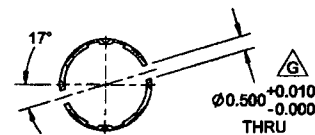
C6-5



C4-5



B5-5

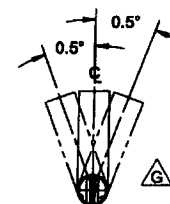
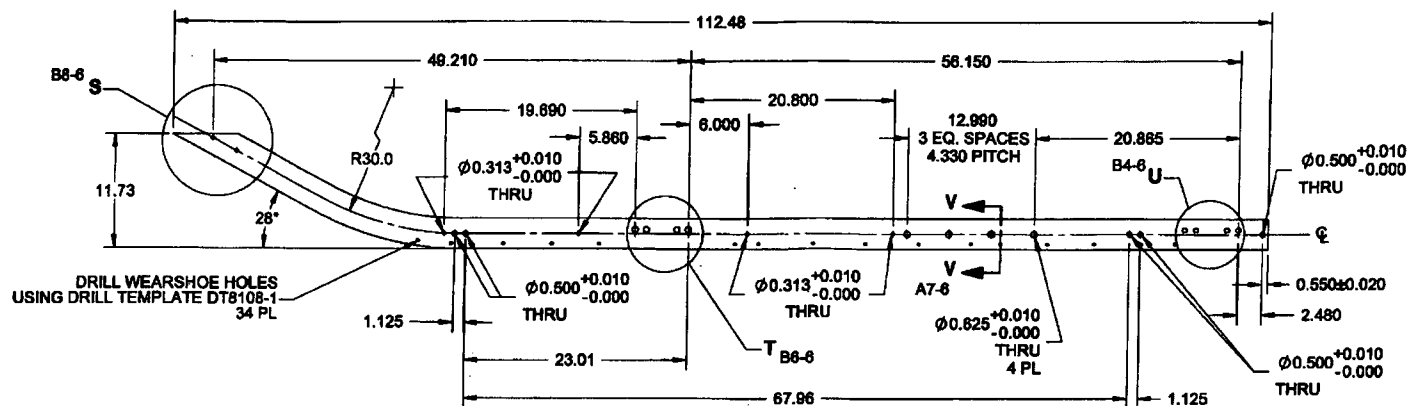


B3-5

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MFG. APPR.		D2750	SHEET 5 OF 11
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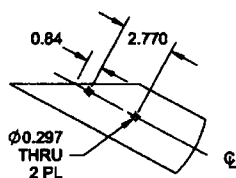
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2013-08-13

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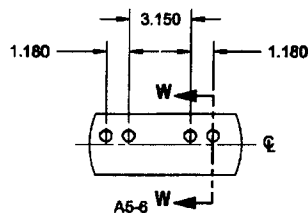


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

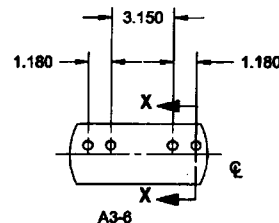
D2750-3 LH SKIDTUBE



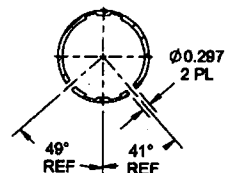
DETAIL S
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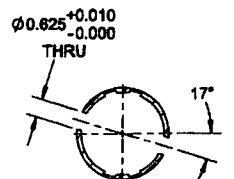
DETAIL T
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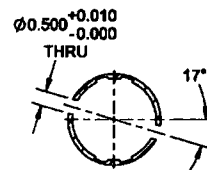
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

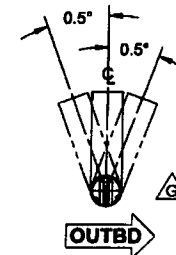
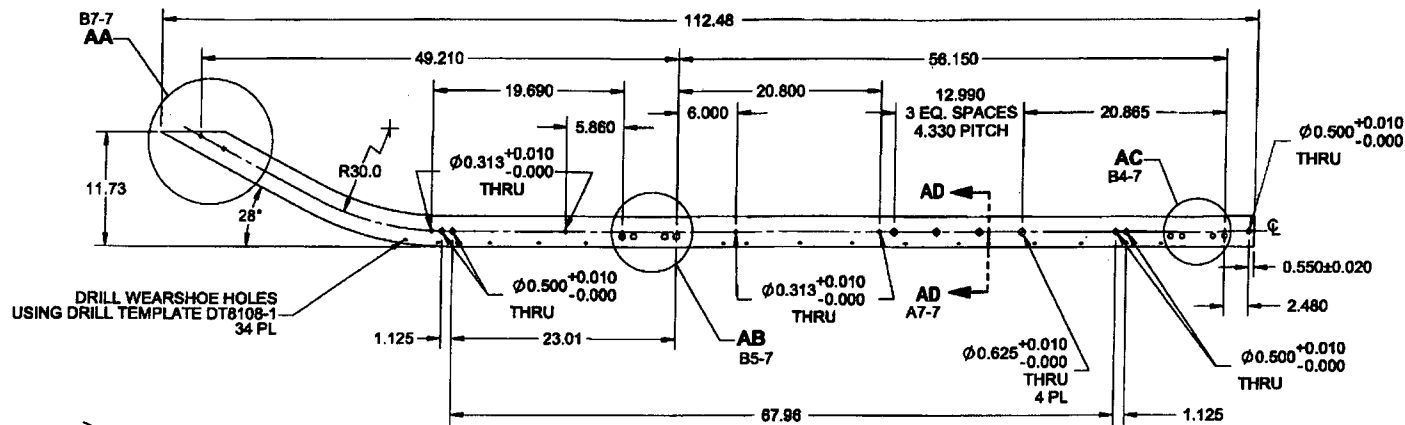


SECTION X-X
SCALE 3X, 4 PL

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2013-08-13

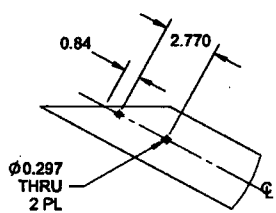
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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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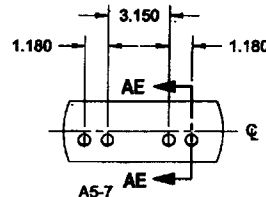


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

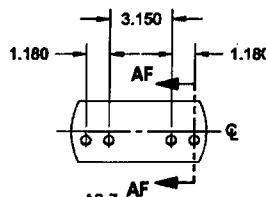
D2750-4 RH SKIDTUBE



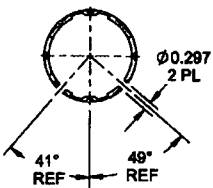
DETAIL AA
SCALE 2X



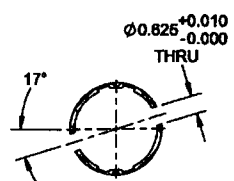
DETAIL AB
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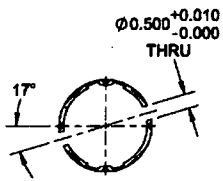
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



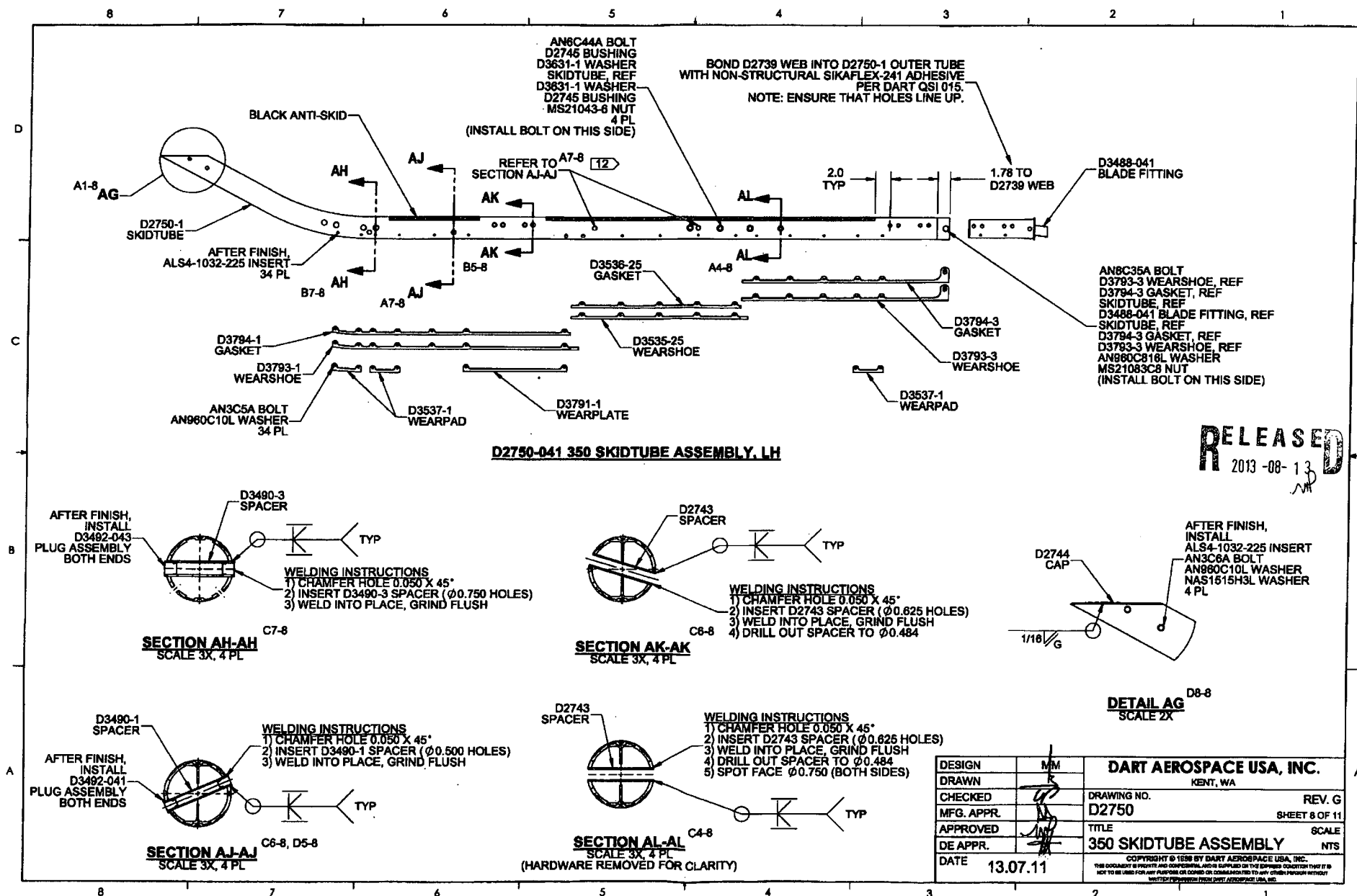
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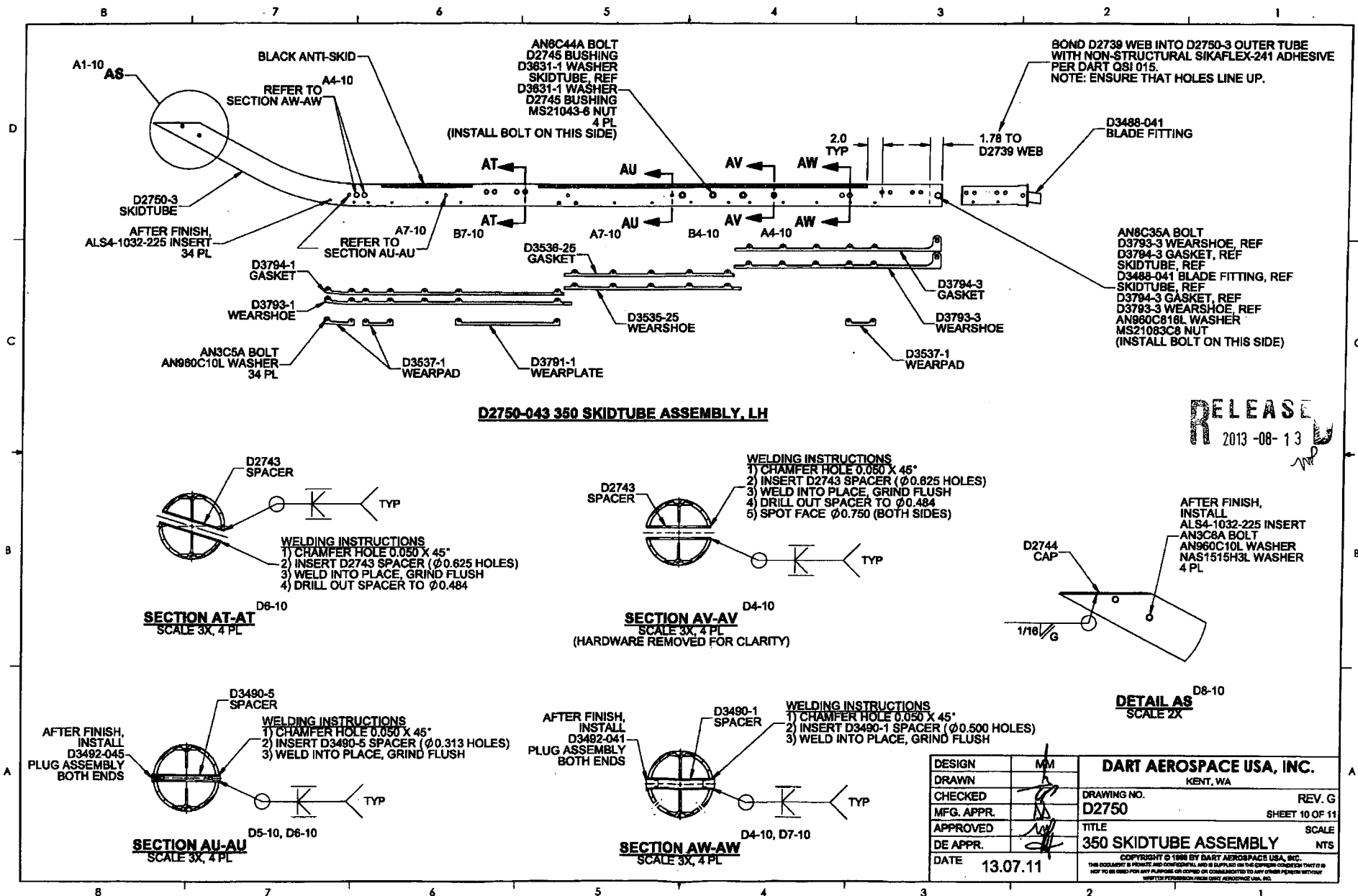


SECTION AF-AF
SCALE 3X, 4 PL

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MFG. APPR.		D2750	SHEET 7 OF 11
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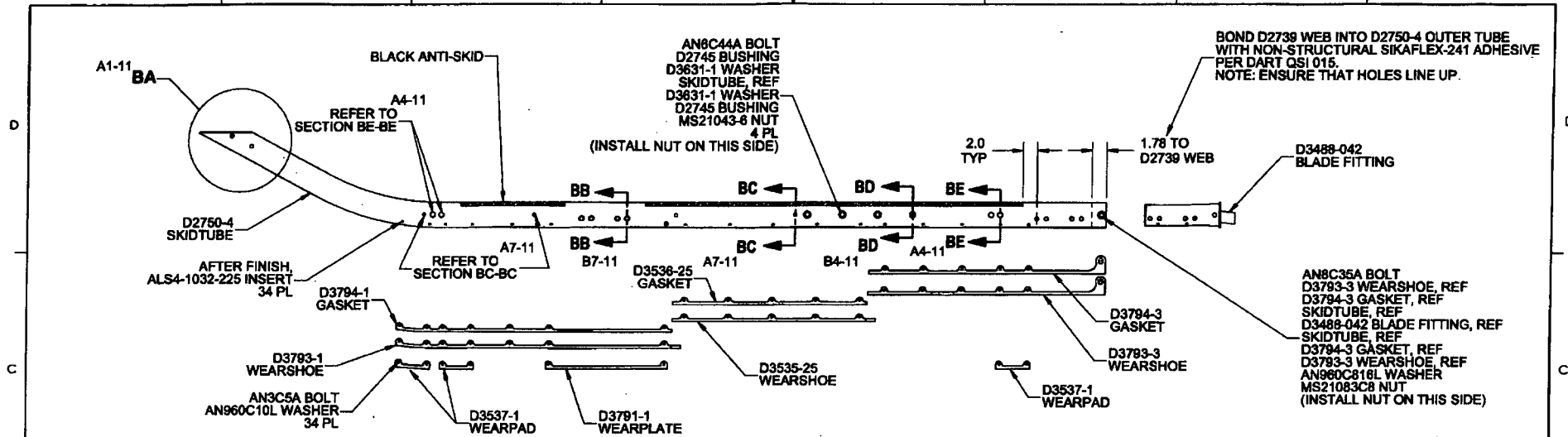




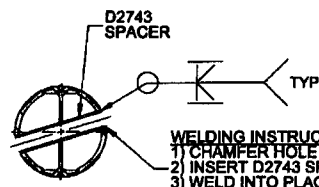
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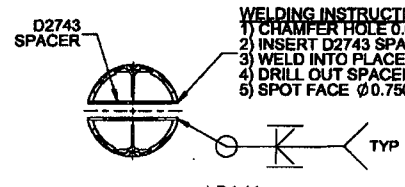
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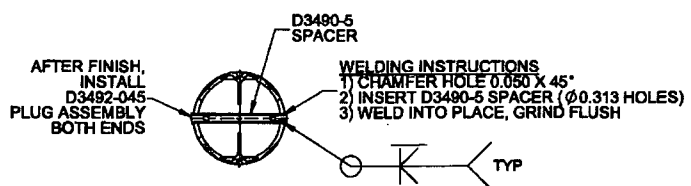
D2750-044 350 SKIDTUBE ASSEMBLY, RH



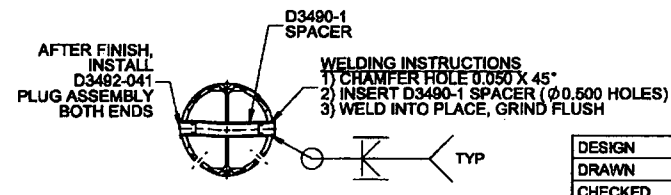
SECTION BB-BB
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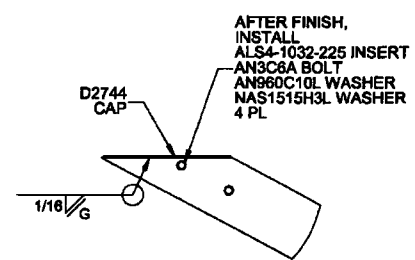
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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